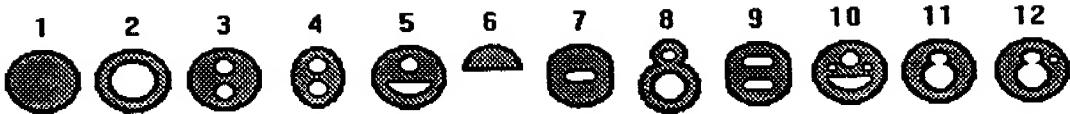


U.S. Ser. No. 09/143,503
U.S. Control No. 90/004,946

Exhibit 20



Request # 2,166

Request Date 4/4/94

Extrusion # 10-556-A

Date Closed

<u>Machine Setup</u>		<u>Tooling</u>	<u>Dimensions</u>					
Zone 1	500 F	<u>Die</u>	Tubing Profile = 02 (Single-Lumen)					
Zone 2	580 F	Dwg. #	High Wall					
Zone 3	570 F	ID / Shape .0700" (50)	Low Wall					
Clamp	F	Land Length Short	% Conc.					
Adapter	578 F	Material Stainless	Basis Wgt.					
Die Body	560 F	Comments Round						
Die Nut	560 F							
		<u>Mandrel</u>	<u>Zumbach</u>					
Brl Melt	F	Dwg. #	<u>Setpoints</u>					
Flg Melt	F	Style Hypotube	Nominal					
Die Melt	700 F	Length 0.650"	Upper					
		Extension Flush	Lower					
Throat	F							
		<u>Miscellaneous</u>	<u>Statistics</u>					
Brl Pres	2589 PSI	Tubing Dwg. #	Avg. Xbar					
Flg Pres	PSI	X-Head Bolt-On	Avg. Sigma					
Die Pres	2213 PSI	Screens 20 200 100 20	Avg. Cp					
		Breaker Plate Single	Avg. Cpk					
			Oval. Xbar					
<u>Screw</u>								
Speed	3.3 RPM	<u>Puller</u>	<u>Water Bath</u>					
Mode	Manual	Speed 71 FPM	Temp Ambient F					
Setting	(%/PSI)	Mode Manual	Air Gap 0.4 "					
Amps	34	Setting (%)	Flow 4 gph					
ID	PET GP		Dam Iris					
<u>Materials</u>		<u>Drying</u>						
<u>%</u>	<u>Part #</u>	<u>Rev</u>	<u>Description</u>	<u>Lot #</u>	<u>Temp.(F)</u>	<u>Time (Hrs)</u>	<u>Dew Pt.</u>	<u>% Moist.</u>
100	VM-NEWKEY-1	A	FORTRON PPS	NONE				
<u>Statistic Comments:</u>								
<u>Machine Comments:</u>								

